



Dart Aerospace Ltd.
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Canada

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DAS
03
9-89

D3274-041BENT
Job Sheet 211891



Part No: D3274-041BENT

Job Qty: 8 pcs

Part Name: Skidtube Assembly 206



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/7/20

Type: Stock

Description:

Note: DWG REV G SHEET 2 IPP REV:A 14.01.17 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	6 pcs	8/7/20	8/7/20	0.12	1.33	Skidtubes - Bend		MLZ
120	QC 5	6 pcs	8/7/20	8/7/20	0.00	0.00	QC 5 - 10		BF 08/11/2020
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		
130	Packaging 3-1 - Stock - B4B	6 pcs	8/7/20	8/7/20	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		



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Container No: S293121



Part: D3274-041BENT

Job No: 211891

Serial No/Batch: S293121

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/10/20

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				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BE 08/11/2020
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	6 pcs	8/7/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 9	2-22
				QC 21 - SA - 77	
Part Op 110 - (Skidtubes) *****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE***** 1- Bend FWD end of tube using bend Descriptions: prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274. 2- Test fit FWD cap. 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: <u>LG002</u>) LOCALITON : LG002 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2600-1-190	Extrusion Round 3" 206	6 pcs (1 ea)	110-Skidtubes - Bend - 1	235271	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Skidtubes - Bend - 1	D2600-1-190	6	29	0	
Part Specifications					
Specifications could not be found.					

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Qty -041	Qty -043	Qty -045	Part Number	Description
X			D3274-041	SKIDTUBE ASSEMBLY
	X		D3274-043	SKIDTUBE ASSEMBLY
		X	D3274-045	SKIDTUBE ASSEMBLY (FOR PHI)
1	1	1	D2600-1-240	EXTRUSION
1	1	1	D2646	AFT CAP
12	12	12	D2649	CROSS BOLT SPACER
12	37	12	D3275-1	CROSS BOLT SPACER
1	1	1	D3282-041	FLOAT WEB
1	1	1	D3285-1	CAP
1	1	1	D3413-1	RING
1	1	1	D3415-041	NUT PLATE
9	9		D3537-1	WEARPAD
		1	D3537-11	WEARPAD
1	1		D3537-3	WEARPAD
		9	D3537-9	WEARPAD
2	2	2	D3672-1	WASHER
1	1		D4956-15	WEARSHOE
1	1		D4956-23	WEARSHOE
1	1		D4956-35	WEARSHOE
1	1		D4956-38	WEARSHOE
78	78	40	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	42	AN3CA4	BOLT
1	1		AN4CSA	BOLT
1	1	1	NAS1149C0463R	WASHER (AN660C416)
80	80	42	NAS1149C0332R	WASHER (AN660C10L)
2	2	2	CCR264SS3-3	RIVET
2	2	2	CR3212-4-03	RIVET
		1	MS27039C4-06	SCREW

GENERAL NOTES:

1. MATERIAL: N/A

2. FINISH:

ON -041/-043: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART QSI 005 4.2 BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4

ON -045: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) INSIDE AND OUTSIDE PER QSI 005 4.2.1 PAINT BLACK PER QSI 005 4.2.2 USING CA8213/F37036 CAMOFLAGE BLACK PER MIL-PRF-05285E TYPE I CLASS H. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4

3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

4. UNITS: INCHES UNLESS OTHERWISE NOTED

5. BREAK SHARP EDGES 0.005 TO 0.010 MAX

6. IDENTIFICATION: N/A

7. WEIGHT: FOR -041/-043 = 37.5 LBS

FOR -045 = 33.4 LBS

8. WELDING TO BE DONE PER DART QSI 004.

9. ALL HOLES DRILLED ON CENTERLINES.

10. DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

11. BOND D3282-041 FLOAT WEB INTO D3274-1/3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.

12. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/291. ON -045, DO NOT DRILL HOLES OR INSTALL INSERTS FOR LONG WEARPLATES.

13. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS GREASE WITH WASH 'N WIPE DEGREASER.

14. ON -045, APPLY COAT OF ROCKGUARD TO SKIDTUBE WHERE WEARPADS ARE INSTALLED.

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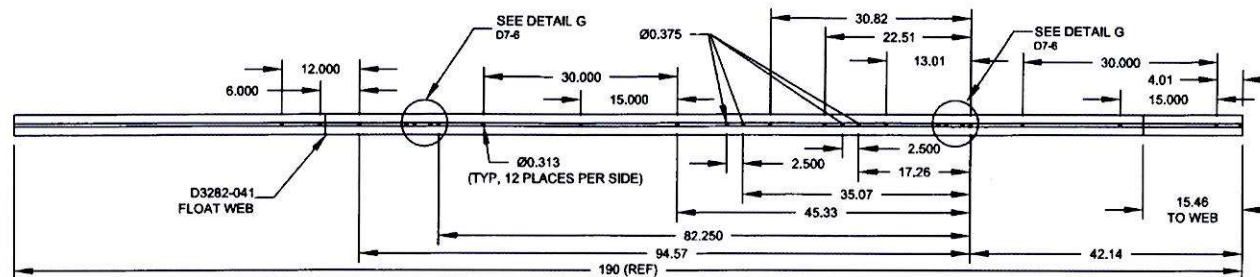
WORK ORDER

NO. 211891 MJS

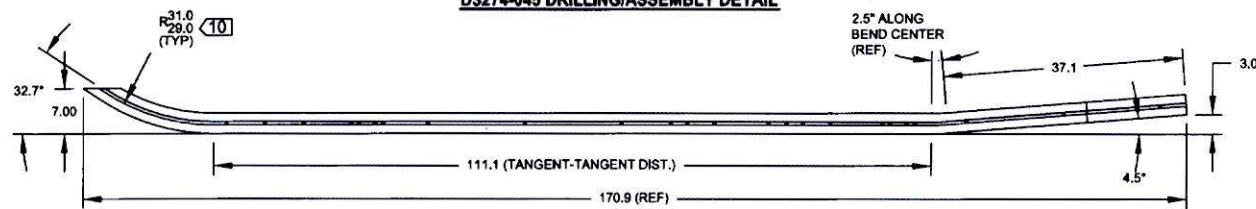
2007-31

G	ADD -045 CONFIGURATION (FOR PHI) ZN A5-4, A5-6 REVISE NOTE 2, 7 & 12, ADD NOTE 14 (ZN A8-1)	DS	16.04.25
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IIN-D208-642 REV Q	DB	14.04.15
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-256	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	06.12.19
C	ADD -043: NEW INSERTS	CP	05.03.16
B	MOVE SADDLE HOLE: 42.14 WAS 42.76	CP	04.08.09
A	NEW ISSUE	CP	04.03.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 1 OF 6
APPROVED	DS	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	16.04.25	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

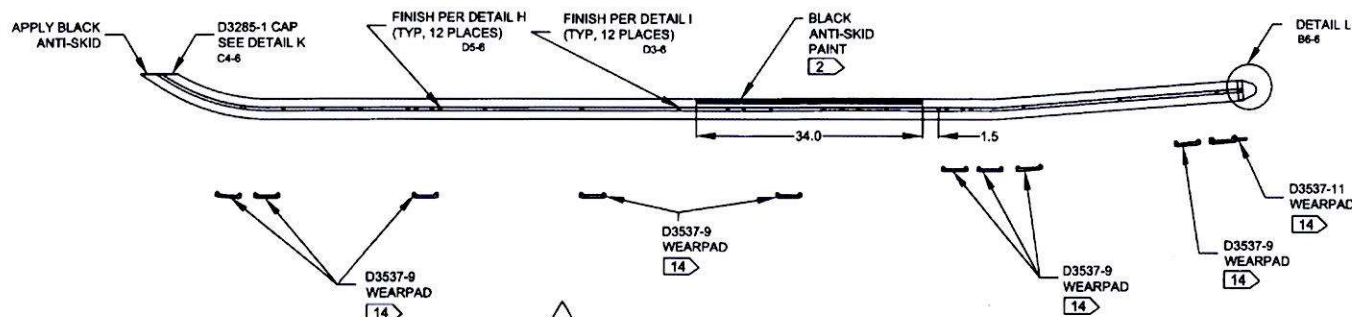
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2016-07-26
ECN 16-616



D3274-045 DRILLING/ASSEMBLY DETAIL



D3274-045 BEND/DRILLING DETAIL

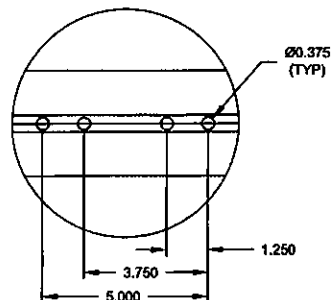


D3274-045 SKIDTUBE ASSEMBLY
(SEE DETAIL J FOR WEARSHOE INSTALLATION)

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2016-07-26

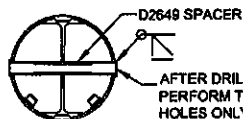
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DETAIL A: DRILL DETAIL
D4-2, D3-2, D5-3, D3-3



DETAIL B
B4-2, B5-3

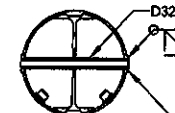
FOR 0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2648 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO 0.313x0.75 DEEP

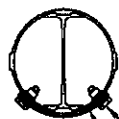
DETAIL C
B5-2, B4-3

FOR 0.313 HOLES ONLY



CHAMFER 0.030x45°
(TYP)

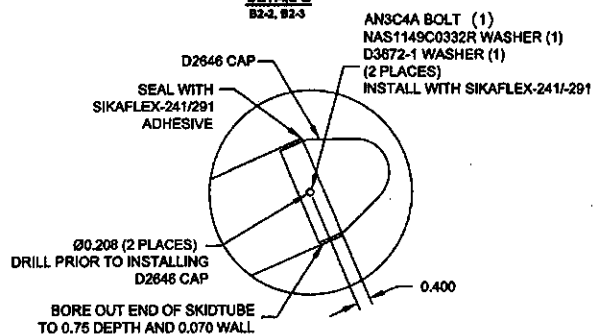
DETAIL D
A4-2, A4-3



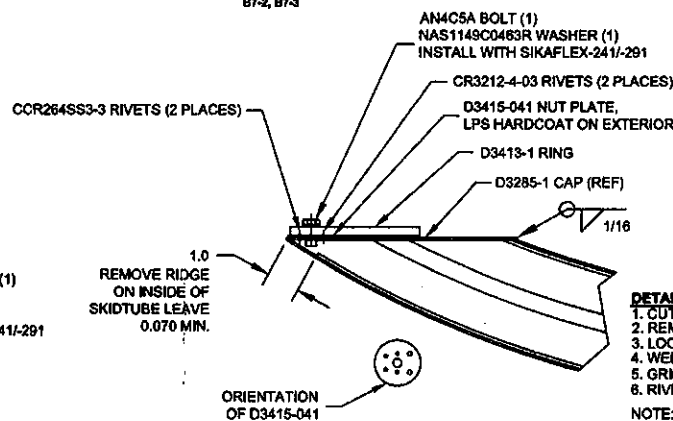
ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
(78 PLACES)

WEARSHOE/WEARPAD (REF)

DETAIL E
B2-2, B2-3



DETAIL F: END FINISHING DETAIL
B7-2, B7-3



DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

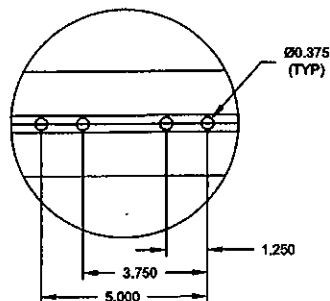
-041/-043 DETAILS

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DE APPR.		SKIDTUBE ASSEMBLY	NTS
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DETAIL G: DRILL DETAIL

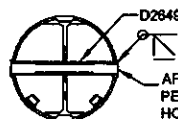
D4-4, D3-4



DETAIL H

B6-4

FOR Ø0.375 HOLES ONLY

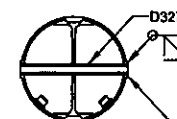


- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL I

B5-4

FOR Ø0.313 HOLES ONLY



CHAMFER 0.030x45° (TYP)

DETAIL J

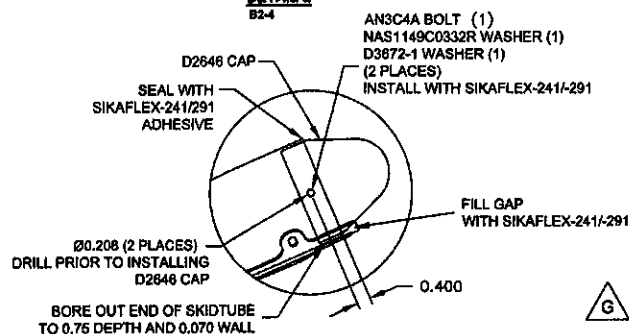
A4-4



- AL57-1032-130 INSERT (1)
AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
(40 PLACES)
WEARPAD (REF)

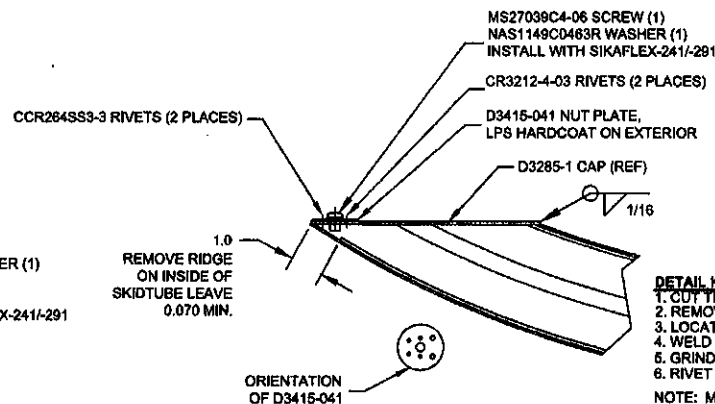
DETAIL L

B2-4



DETAIL K: END FINISHING DETAIL

B7-4



DETAIL K NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH



-045 DETAILS

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2016-07-26

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					